

Date: Tuesday, 13/05/2008 11:08:47 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DECK PLATE,FWD ,350 LITTER KIT
Job Number : 39239	
Estimate Number : 11104	
P.O. Number :	Part Number : D2364
This Issue : 13/05/2008 S.O. No. :	Drawing Number : D2364 REV.F
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : F
Previous Run : 38057	Material :
Written By :	Due Date : 05/06/2008 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 08.5.13</u>	
Comment : EST. REV. E 00.06.26 Removed P/O for powder coat EC Est Rev:F Now On Waterjet 06-07-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.6792 sf(s)/Unit Total : 4.0755 sf(s) HB 8-5-14
 2024-T3 .063 Aluminum sheet $10492 \times 3 = 2.1$
 (M2024T3S063) 101022×1.7
 Batch: $105615 \times 3 = 2.1$

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2364
 Dwg Rev: F
 Prog Rev: F

HB 8-5-14

⑦

2-Deburr if necessary HB 8-5-14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-5-14

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08/05/15 (x7)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- counter sink holes as per dwg D2364

EB 08/05/16 ⑦

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/05/2008 11:08:47 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 39239

Part Number: D2364

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- deburr if necessary

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:20 am

320°F

7:30 am

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57186

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39239
Description: Litter Deck Plate Kit (350)		Part Number: D2364
Inspection Dwg: D2364	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.626	*			
Ø0.171	+0.005/-0.000	.173	*			
0.354	+/-0.010	.355	*			
11.242	+/-0.010	11.242	*			
3.031	+/-0.010	3.038	*			
1.903	+/-0.010	1.903	x			
1.128	+/-0.010	1.125	*			
0.354	+/-0.010	.355	*			
1.340	+/-0.005	1.354	*			
2.326	+/-0.010	2.330	*			
3.312	+/-0.010	3.316	*			
4.298	+/-0.010	4.301	*			
5.284	+/-0.010	5.286	*			
6.151	+/-0.010	6.155	*			
6.270	+/-0.010	6.272	*			
0.354	+/-0.010	.354	*			
3.031	+/-0.010	3.036	*			
Ø0.656	+0.005/-0.000	.656	*			
5.003	+/-0.010	5.003	*			
4.605	+/-0.010	4.607	*			
1.776	+/-0.010	1.776	*			
0.980	+/-0.010	.980	*			
4.487	+/-0.010	4.490	*			
7.192	+/-0.010	7.194	*			
7.587.567	+/-0.010	7.570	*			
7.942	+/-0.010	7.947	*			
Ø0.191	+0.005/-0.000	.192	*			
Ø0.197	+0.005/-0.000	.200	*			
11.145	+/-0.010	11.145	*			
12.181	+/-0.010	12.181	*			
11.378	+/-0.010	11.378	*			
11.776	+/-0.010	11.776	*			
12.173	+/-0.010	12.173	*			
4.690	+/-0.010	4.691	*			
0.250	+0.005/-0.000	.251	*			
3.141	+/-0.010	3.145	*			
0.171	+0.005/-0.000	.173	*			

Measured by: B	Audited by: [Signature]	Prototype Approval:	N/A
Date: 8-5-14	Date: 08/05/15	Date:	N/A

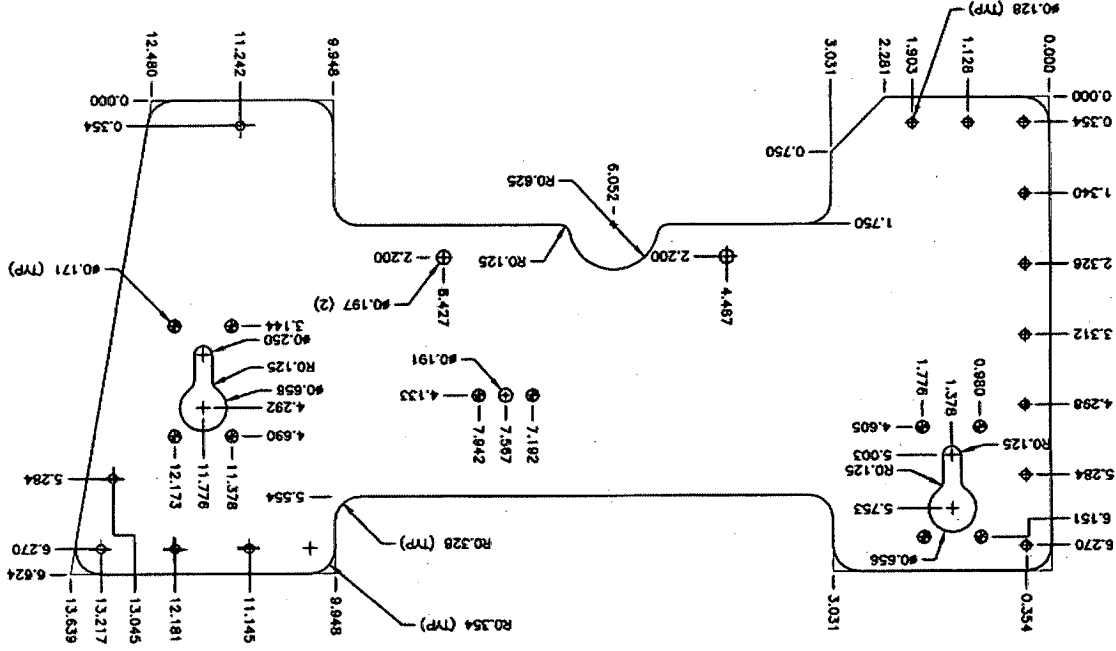
Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	[Signature]



98/06/22 KG

COUNTER SINK HOLES:
 ♦ C'SINK Ø0.225 x 100° (UPDATED FROM 9 TO 14 HOLES AT 05 99.03.01 TO CORRECT CAD ERROR)
 ● C'SINK Ø0.308 x 100°

COUNTER SINK HOLES:
C'SINK Ø0.225 x 100°
C'SINK Ø0.308 x 100°



MATERIAL: 2024-T3 (00-A-250/5) 0.063-0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED
JECT TO AMENI

WITHOUT NOTICE
WORK ORDER

NO. 7-23